PRODUCT DATA SHEET
Sikaflex®-511

Textured, isocyanate free, low modulus sealant

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical base</td>
<td>Silane Terminated Polymer</td>
</tr>
<tr>
<td>Color (CQP001-1)</td>
<td>White, aluminum gray, dark bronze, tan, anodized aluminum, stone, off-white, medium bronze, black, limestone, special bronze</td>
</tr>
<tr>
<td>Cure mechanism</td>
<td>Moisture-curing</td>
</tr>
<tr>
<td>Density (uncured)</td>
<td>1.44 kg/l</td>
</tr>
<tr>
<td>Non-sag properties</td>
<td>Very good</td>
</tr>
<tr>
<td>Application temperature</td>
<td>ambient 5 – 40 °C (41 – 104 °F)</td>
</tr>
<tr>
<td>Skin time (CQP019-1)</td>
<td>70 minutes A</td>
</tr>
<tr>
<td>Curing speed (CQP049-1)</td>
<td>See diagram 1</td>
</tr>
<tr>
<td>Shore A hardness (CQP023-1 / ISO 48-4)</td>
<td>20</td>
</tr>
<tr>
<td>Tensile strength (ASTM D412)</td>
<td>0.7 MPa (100 psi)</td>
</tr>
<tr>
<td>Elongation at break (ASTM D412)</td>
<td>350 %</td>
</tr>
<tr>
<td>Tear propagation resistance (CQP045-1 / ISO 34)</td>
<td>6 N/mm (35 pli)</td>
</tr>
<tr>
<td>Service temperature (CQP513-1)</td>
<td>-40 – 77 °C (-40 – 170 °F)</td>
</tr>
<tr>
<td>Shelf life (CQP016-1)</td>
<td>12 months B</td>
</tr>
</tbody>
</table>

CQP = Corporate Quality Procedure

DESCRIPTION
Sikaflex®-511 is a 1-component, high movement Silane Terminated Polymer (STP) textured sealant that cures on exposure to atmospheric humidity. It is well suited for applications that require both paintability and adhesion to non-porous substrates.

PRODUCT BENEFITS
- Meets the requirements of ASTM C1248, ASTM C920 Type S, Grade NS, Class 50, Use M (w/ Sika® Primer-210), A, O-Vinyl
- Good weathering resistance
- Designed for porous and non-porous substrates
- Textured appearance blends well to rough or stucco type surfaces
- Isocyanate free
- Overpaintable with most paints

AREAS OF APPLICATION
Sikaflex®-511 can be used for joints or gaps connecting dissimilar substrates such as vinyl to concrete or aluminum to EIFS. Seek manufacturer’s advice and perform tests on original substrates before using Sikaflex®-511 on materials prone to stress cracking. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.
Cure Mechanism
Sikaflex®-511 cures by reaction with atmospheric moisture. At low temperatures the water content of the air is generally lower and the curing reaction proceeds somewhat slower (see diagram 1).

Method of Application
Surface Preparation
Surfaces must be clean, dry and free from grease, oil, dust and contaminants. Surface treatment depends on the specific nature of the substrates and is crucial for a long lasting bond. Suggestions for surface preparation may be found on the current edition of the appropriate Sika® Pre-Treatment Chart. Consider that these suggestions are based on experience and have in any case to be verified by tests on original substrates.

Application
Sikaflex®-511 can be processed between 5 °C and 40 °C (41 °F and 104 °F), climate and product, but changes in reactivity and application properties have to be considered. The optimum temperature for substrate and process material is between 15 °C and 25 °C (59 °F and 77 °F). Sikaflex®-511 can be processed with manual, pneumatic or electric driven piston guns.

Tooling and Finishing
Tooling and finishing must be carried out within the skin time of the product. It is recommended using Sika® Slick. Other finishing agents must be tested for suitability and compatibility prior to use.

Removal
Uncured Sikaflex®-511 may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically. Hands and exposed skin have to be washed immediately using a suitable industrial hand cleaner and water. Do not use solvents on skin.

Overpainting
Sikaflex®-511 can be best painted within the skin formation time. If painting process takes place after the sealant has built a skin, adhesion could be improved by treating the joint surface with Sika® Activator-100 or Sika® Activator-205 prior to paint process. If the paint requires a baking process (> 80 °C (176 °F)), best performance is achieved by allowing the sealant to fully cure first. All paints have to be tested by carrying preliminary trials under manufacturing conditions. The elasticity of paints is usually lower than that of sealants. This could lead to cracking of the paint in the joint area.

Application Limits
- Maximum depth of sealant must not exceed 13 mm (1/2 in.); minimum depth is 6 mm (1/4 in.).
- Not intended for immersion, structural glazing applications, or horizontal vehicular traffic.
- Do not apply to damp or wet substrates.
- Allow treated wood to age six months before application.

Further Information
The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry. Copies of the following publications are available on request:
- Safety Data Sheets
- Sika Pre-treatment Chart
- For Silane Terminated Polymers
- General Guideline
- Bonding and Sealing with 1-component Sikaflex®

Packaging Information

<table>
<thead>
<tr>
<th>Cartridge</th>
<th>295 ml</th>
</tr>
</thead>
<tbody>
<tr>
<td>Unipack</td>
<td>600 ml</td>
</tr>
</tbody>
</table>

Basis of Product Data
All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

Environmental, Health and Safety
For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

Legal Disclaimer
Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates (“Sika”), the user must always read and follow the warnings and instructions on the product’s most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting Sika’s Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any Sika literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the Sika product. Sika warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product’s shelf life. User determines suitability of product for intended use and assumes all risks. User’s and/or buyer’s sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. No other Warranties Express or Implied Shall Apply Including Any Warranty of Merchantability or Fitness for a Particular Purpose. Sika Shall Not Be Liable Under Any Legal Theory For Special or Consequential Damages. Sika Shall Not Be Responsible for the Use of This Product in a Manner to Infringe on Any Patent or Any Other Intellectual Property Rights Held by Others. Sale of Sika products are subject to the Terms and Conditions of Sale which are available at https://usa.sika.com/en/group/SikaCorp/termsandconditions.html or by calling +1 800-933-7452.